

Work Order ID 98348***98348***

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March-12-13 1:47:59 PM

Item ID:	D3916-041	Accept	*N900040100*	Setup	Start	*NS1*		
Revision ID:					Stop	*NS2*		
Item Name:	Rib Assembly							
Start Date:	3/11/13	Start Qty:	4.00	*4*				
Required Date:	3/29/13	Req'd Qty:	4.00	*4*				
Reference:				Cust Item ID:				
Approvals:	Process Plan:	ML5	Date: 13-03-14	Tooling:	Date:	Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A	0.00							
100									
100									
Large Fab	Memo	0.00							
Large Fab	1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9567 *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending*** 3- Trim access tube material to finish size as per dwg D3916 4- Drill and chamfer holes as per dwg D3916-1 using DT9605								
105	QC6- Inspect dimensions to drawing	0.00							
105									
QC	Memo	0.00							
Quality Control									

(PL 13-03-20) 4x

(4) 13-03-20

DAS
09
08

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	

Work Order ID 98348

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Item ID: D3916-041**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Rib Assembly**Start Date:** 3/11/13**Start Qty:** 4.00***4*****Cust Item ID:****Required Date:** 3/29/13**Req'd Qty:** 4.00***4*****Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:****Run Start*****NR1*****QC:****Date:****SPC (Y/N):****Date:****Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

107

107

Large Fab

Weld per dwg A/R S.S. rod Batch: *104816*

0.00

*CPL 13-3-20**4x*

Large Fab

Memo

0.00

1- weld bushing as per dwg D3916
2- grind welds flush

110

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*13-03-20**DAS
09*

120

120

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

*13-03-20**DAS
09***Memo**

0.00

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
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Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending	General			Grain			Ovalized	Pressure/Forced		
	Centre Not Concentric to O/S	Bend	General			Hardware			Over/Under tolerance	Temperature/Cure	
	Cracks	BOM/Route	General			Inspection Incomplete			Part Incorrect	Weld	
	Crushed/Crimped.	Broken/Damaged	General			Instructions Incomplete/Unclear			Part Lost/Missing	Wrong Stock Pulled	
	Cuffs	Burrs	General			Maintenarce			Part Moved		
	Heat Treat	Contamination	General			Mislabeled			Positioned Wrong		
	Inspection Strip in Tube	Countersink	General			Misread			Power Loss/Surge		
	Ripples in Bend	Cut Too Short	General			Offset			Other		
	Torque Waves in Extrusion	Drill Holes	General			Out of Calibration					
	Turning Sequence	Drawing	General			Out of Sequence					
	Wave/Twist in Tube	Finish	General			Outside Dimensions					
		Folio	General								
			General								
			General								

Work Order ID 98348***98348***

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Item ID: D3916-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rib Assembly

Stop

NS2

Start Date: 3/11/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/29/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Identify as per dwg & Stock Location: <i>WA 4</i>	0.00	<i>CPL</i>	<i>13-320</i>		<i>4</i>			
Packaging	Memo	0.00							

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

*MJ 13-03-20**AB-63-20*

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
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FAULT CATEGORY											
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	

Picklist Print

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Work Order ID: 98348

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Start Date: 3/11/13

Required Date: 3/29/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
verified by:EC

IPP Rev:B as per dwg revA 10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			100	Each	210.0000	7	28			Col 13.3.20

Location	Loc Qty	Loc Code
WA004	210	
66489	1	
79213	1	
83464	7	
86550	20	
88236	98	
89780	11	
90786	72	

M304TS0.750W.049 304 SQ Tube .75x.75x.049W	Purchased	No		100	f	735.4684	4.166	17.541053	Col 13.3.20
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Location	Loc Qty	Loc Code
MAT017	500.5358	
124492	500.5358	
WA006	234.9326374	
123219	57.1601515	
123484	177.772486	

1755

NCR: Yes / No

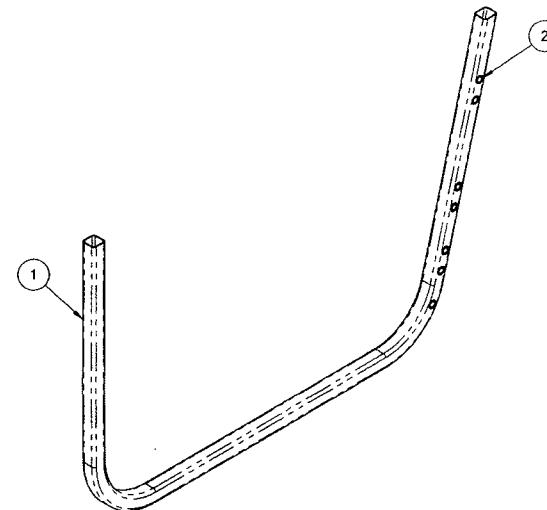
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

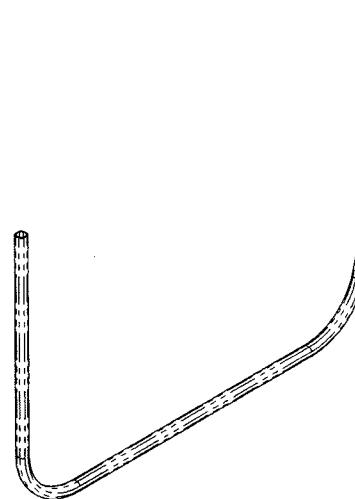
QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
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FAULT CATEGORY											
Landing Gear				General							
				Bend BOM/Route Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions	Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled				
				Folio	Other						

ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

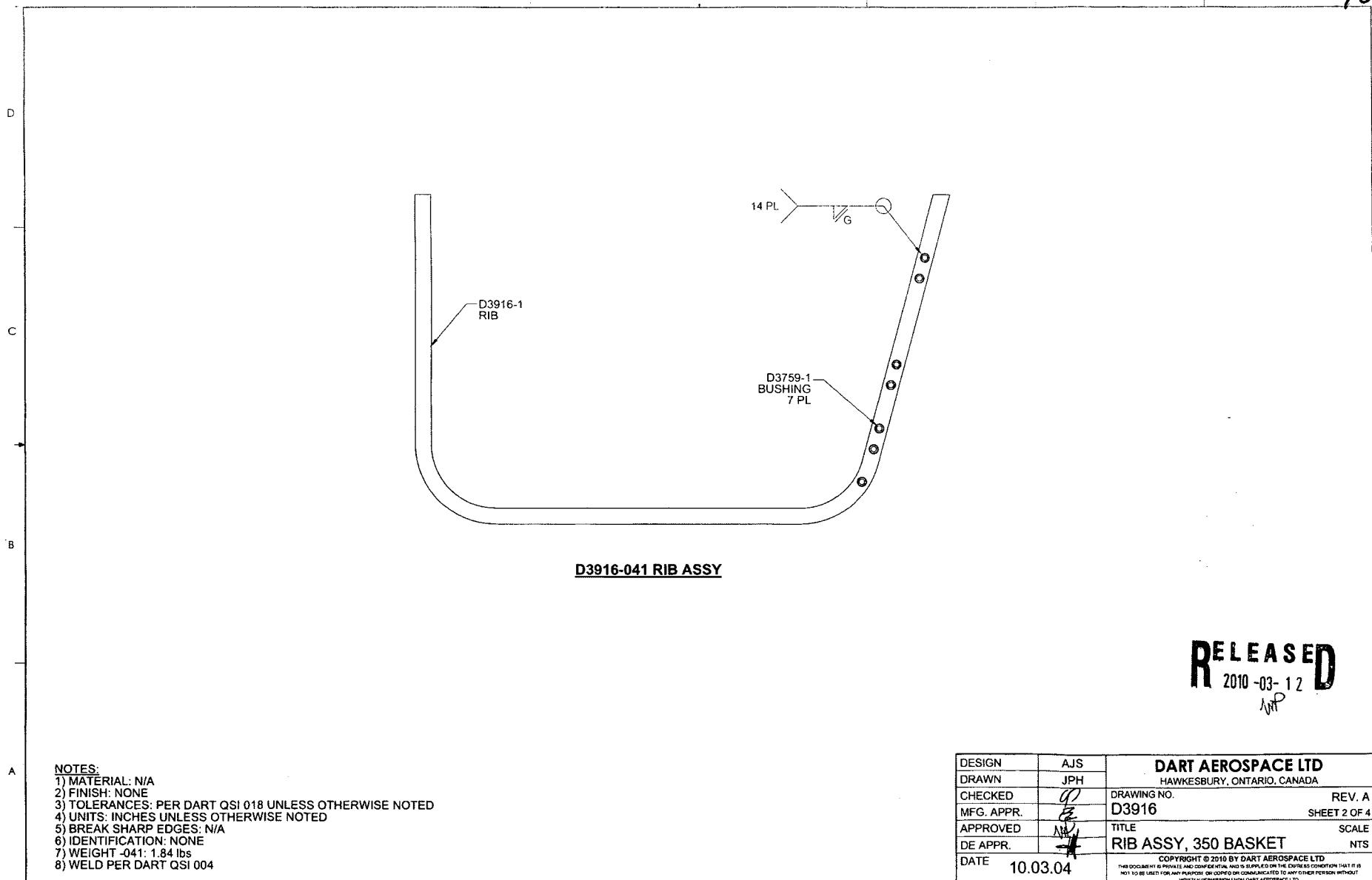
SJ
 R
 E
 UNCON
 SUBJECT
 WI
 W
 40-98348 MLJ
 13-03-14

OR 10.12.21
 UNDER REVIEW
 A 10-19
 ADDITION OF HOLE + BUSHINGS
 ON D3916-041-1 RIBS.

RELEASED
 2010-03-12
 JAP

A	NEW ISSUE	JP	10.03.04
REV.	BY	DATE	
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Q</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>Q</i>	D3916	SHEET 1 OF 4
APPROVED	<i>Q</i>	TITLE	SCALE
DE APPR.	<i>Q</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS EXPRIMED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITH OUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

98348

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2010-03-12
AM

